



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5854-041
Job Sheet 207404

NO 20.02.20



POSITIVE
RECALL

POSITIVE RECALL

Part No: D5854-041

Job Qty: 8 pcs

Part Name: Bracket Weldment



Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

Priority: Medium

Placed by M. St. Hilaire
APR 20.02.20

Note: URF 2020-525 DWG D5854 Rev A IPP Rev. A 2020.01.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Welded Assy-1	8 pcs	3/6/20	3/6/20	0.00 8.00	Large Fab - 1		
						Large Fab - 10		
						Large Fab - 2		
						Large Fab - 3		
						Large Fab - 4		
						Large Fab - 5		
						Large Fab - 6		
						Large Fab - 7		
						Large Fab - 8		
						Large Fab - 9		
						Large Fab - 11 (Various)		
						Large Fab - 12		
120	QC 9	8 pcs	3/6/20	3/6/20	0.00 0.00	QC 9 - 10		
						QC 9 - 18		
						QC 9 - 24	DAS 24	
						QC 9 - 43	9-89	
						QC 9 - 50		
						QC 9 - 9		
130	QC 5	8 pcs	3/6/20	3/6/20	0.00 0.00	QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19	DAS 24	
						QC 5 - 22	9-89	
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		
						QC 5 - 68		

PRIORITY

MAL



Container No: S267896



Part: D5854-041

Job No: 207404

Serial No/Batch: S267896

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 03/31/20

Plex 2/26/20 9:58 AM Dart.lajeunesse.marie

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140	Packaging 3-1 - Stock - B4B	8 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
150	QC 21 - SA	8 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - Weld per dwg A/R S.S. rod Batch: M139022

Descriptions: 120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - (QC5- Inspect part completeness to step on W/O)

140 - Identify as per dwg & Stock Location:

150 - QC21- Final Inspection - Work Order Release

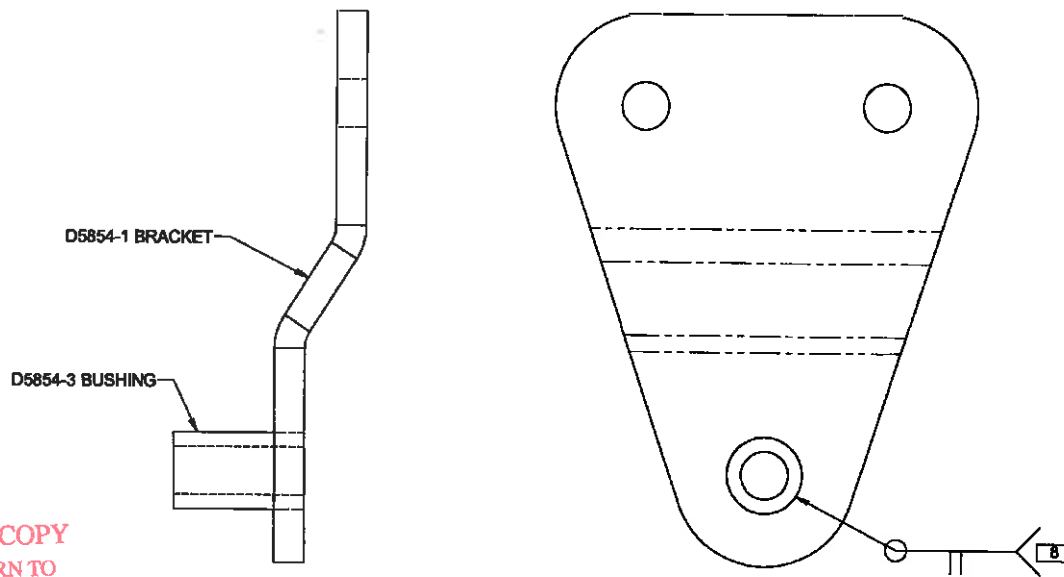
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5854-1	Bracket	8 pcs (1 ea)	110-Large Fab - Welded Assy-1	5259 113
D5854-3	Bushing	8 pcs (1 ea)	110-Large Fab - Welded Assy-1	5259 588

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D5854-1	8	0	0
	D5854-3	8	0	0
Part Specifications				
Specifications could not be found.				

Plex 2/26/20 9:58 AM Dart.lajeunesse.marie

QTY -041	P/N	DESCRIPTION
X	D5854-041	BRACKET WELDMENT
1	D5854-1	BRACKET
1	D5854-3	BUSHING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207404 MJS
20-02-26

D5854-041 BRACKET WELDMENT
(DERIVED FROM AERO DESIGN P/N 70422-06)

UNDER REVIEW
URF 2020-525 20.02.20 (NO)

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER DART QSI 044
7) WEIGHT: 0.10 lbs
8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.

RELEASED
2020 FEB 19
ECN 2020-524

A NEW ISSUE		ZF	20.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.27		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. D5854		SHEET 1 OF 3
TITLE BRACKET		SCALE NTS

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APPROVED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					